Dart Aerospace Ltd. Monday, 10/22/2007 3:22:58 PM Date: User: Kim Johnston **Process Sheet Drawing Name** : PLUG Customer : CU-DAR001 Dart Helicopters Services Job Number **Estimate Number** : 12919 : D26511UP Part Number P.O. Number D2651 REV. B : 10/22/2007 S.O. No. : **Drawing Number** This Issue : NC Project Number : N/A Prsht Rev. : B : // First Issue Type : MACHINED PARTS **Drawing Revision** : 34185 Material Previous Run 300 Um: : 11/15/2007 **Due Date** Written By Checked & Approved By : Est Rev New Issue 07-07-04 JLM Comment **Additional Product** Job Number: Machine Or Operation: Seq. #: Description: 6061-T6 Round Bar .500" 1.0 M6061T6R0500 Comment: Qty.: 0.0421 f(s)/Unit Total: 12.6315 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: M105 67 2.0 HARDINGE Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651 2- Deburr 3.0 QC2 Comment: INSPEC PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8

Comment: SECOND CHECK

SMALL FAB 5.0

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr ias per dwg D2651



Each

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	P PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		4-							
							*		
		41							

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B	<del>- , - , </del>	Varification	Approval Chief Eng				
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspecto			
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NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:22:58 PM User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: PLUG Part Number: D26511UP Job Number: 35266 Job Number: Description: Seq. #: Machine Or Operation: HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 QC3 Comment: INSPECT POWDER COAT 8.0 PACKAGING 1 PACKAGING RESOURCE#1 Comment: PACKAGING RESOURCE #1 Identify and Stock

Location:\_ 9.0 QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



a d.11.07

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								:		

Part No:	PAR #:	Fault Category:	 NCR: Yes	No	DQA:	Date:	
			QA: N	1/C C	losed:	Date:	

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Varification	A	Approval QC Inspector		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng			
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Chief Eng Chief	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng Chief Eng Sign & Date Chief Eng Chi		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35266
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	0.061	<b>/</b>			
0.375	+/-0.010	0.375	/			
0.050 x 20°	+/-0.010	0.050x20°	<b>_</b>			
Ø0.305	+0.000/-0.002	0.3045	/			
Ø0.438	+/-0.005	0.438	$\checkmark$			
0.060	+/-0.005	0.059	/			
0.090	+0.000/-0.002	0.088				
0.045	+0.000/-0.002	0.0435	<b>✓</b>			
		,	,			
		,				,

Measured by:	Audited by: <	36	Prototype Approval:	N/A	
Date: 07/11/01	Date:	07.11.02	Date:		

Rev	Date	Change	Revised by	Approved
Α	03.12.22	New Issue	KJ/RF	· ‡
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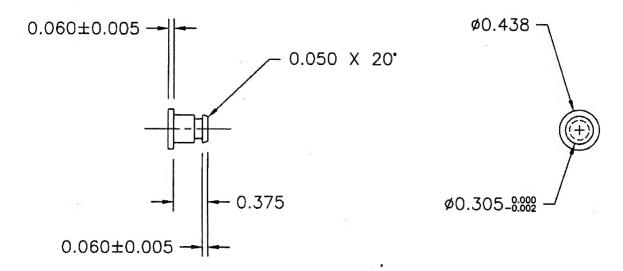




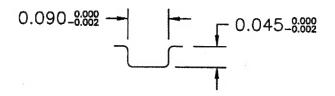
DESIG	4	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	ED	APPROVED	DRAWING NO.	REV. B
4	#	At .	D2651 SHEET	1 OF 1
DATE	*		TITLE	SCALE
03.1	2.19		PLUG	1:1
Α		97.03.25	NEW ISSUE	
В		03.12.19	ADD POWDER COAT, MS28775-008	

# O3.12.19

#### D2651-1 PLUG:



## **GROOVE DETAIL (SCALE 5:1)**



#### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTEDOP COPY
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

## D2651-3 O-RING

1) MATERIAL: BUNA N, 70 DUROMETER 3/16 ID, 5/16 OD, 1/16 WIDTH (PARKER 2-008, MS28775-008 OR EQUIVALENT)

RETURN TO

ENGINEERING UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

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